



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6522A00231-W142S-3T

Job Sheet 199132



Part No: RBW6522A00231-W142S-3T **Job Qty:** 5 pcs

Part Name: Tail Rotor Gear Box/Mast Output Oil Seal Assembly Support Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Due Date: 10/7/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6522A00231-W142S-3T Rev 2 IPP Rev A 18.02.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Lead Time	Sign-off
92	Purchasing	5 pcs		10/7/19	0.00 0.00	Purchasing - 1		
						Purchasing - 2		
						Purchasing - 3		
94	Packaging 2-1 - Receive - B4B	5 pcs		10/7/19	0.00 0.00	Packaging 2 - 1 - B4B		
						Packaging 2 - 2 - B4B		
						Packaging 2 - 3 - B4B		
						Packaging 2 - 5 - B4B		
						Packaging 2 - 4 - B4B		
						Packaging 2 - 6 - B4B		
						Packaging 2 - 7 - B4B		
						Packaging 2 - 8 - B4B		
						Packaging 2 - 9 - B4B		
						Packaging 2 - 10 - B4B		
						Packaging 2 - 11 - B4B		
						Packaging 2 - 12 - B4B		
						Packaging 2 - 13 - B4B		
						Packaging 2 - 14 - B4B		
						Packaging 2 - 15 - B4B		
						Packaging 2 - 16 - B4B		
						Packaging 2 - 17 - B4B		
						Packaging 2 - 18 - B4B		
						Packaging 2 - 19 - B4B		
						Packaging 2 - 20 - B4B		
						Packaging 2 - 21 - B4B		
						Packaging 2 - 22 - B4B		
						Packaging 2 - 23 - B4B		
						Packaging 2 - 24 - B4B		
						Packaging 2 - 25 - B4B		
						Packaging 2 - 26 - B4B		
						Packaging 2 - 27 - B4B		
						Packaging 2 - 28 - B4B		



Container No: S217911



Part: RBW6522A00231 - W142S - 3T

Job No: 199132

Serial No/Batch: S217911

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 09/27/19

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
96	QC 6	5 pcs	10/7/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	OCT 0 3 2019 DAS 40 9-89
					QC 6 - 81	
110	Conventional Lathe - 1 - B4B	5 pcs	10/7/19	0.00 1.67	Conventional Lathe - 1 - B4B	
					Conventional Lathe - 2 - B4B	OCT 2 2 2019 DAS 21 9-89
120	QC 2	5 pcs	10/7/19	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	DAS 21 9-89
					QC 2 - 44	
					QC 2 - 45	OCT 2 2 2019
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
130	QC 8	5 pcs	10/7/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	OCT 2 2 2019 DAS 21 9-89
					QC 8 - 32	
					QC 8 - 33	

				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	B4B
				QC 8 - 8	21
				QC 8 - 9	9-58
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150	Outsource - 4 - Anodize	5	10/7/19	0.00 0.00	ATG001
		pcs			2019-10-04
160	Packaging 2-1 - Recelve - B4B	5	10/7/19	0.00 0.00	Packaging 2 - 1 - B4B
		pcs			Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
170	QC 6	5	10/7/19	0.00 0.00	QC 6 - 9
		pcs			QC 6 - 68
					QC 6 - 61
					QC 6 - 40

				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	5 pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	MLL
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - FG	5 pcs	10/7/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	9.89
Part Op 92 - (Purchasing) 1- Issue P/O to Arrow Tech Machine Works P/O# <u>HB044262</u> 2- Manufacture RBW6522A00231- Descriptions: W142S-3T as per DWG 3- Certificate of conformity is required 94 - (Receive & Inspect for Damage & Mat'l Certs) 96 - (QC6- All purchased or subcontracted products) 110 - (Manufacture as per dwg) 1-Machine as per DWG 2-Deburr . 120 - (QC2- Inspect parts off machine FAI/FAIB) 1-Engrave T/N & S/N number as required Using Marktronic engraver as per DWG 130 - (QC8- Inspect parts - second check) 150 - (Outsource process-Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: <u>44694</u> -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required 160 - (Receive & Inspect for Damage & Mat'l Certs) 170 - (QC6- All purchased or subcontracted products) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release) x5 P/len aug 14 2019					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
RBW6522A00231-W142S-3TP	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Support	5 Ea (1 ea)	92- Purchasing	5217743	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
92-Purchasing	RBW6522A00231-W142S-3TP	5	5	0
Part Specifications				
Specifications could not be found.				

Plex 9/27/19 11:26 AM dart.lussier.patrick

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Skid-tube ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Machining ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Large Fab ☐				MRB (QSI042)					
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QSI042)							
Description Work Order Deviation						Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY							
						Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
						Other/Details: _____							
Completed By						Lead hand / Supervisor							
QC / QA Coordinator													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044262**



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB044262

PO Date: 8/14/19

Due Date: 10/2/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	199130	RBW6522A00231-W142AJ-3TP			Tail Rotor Gear Box/Servo Actuator Oil Seal Fit/Extracting Tool As Per Dwg RBW6522A00231-W142AJ-3T Rev. 5	Firmed -		10/2/19	3 Ea	0 Ea	3 Ea	\$2,061.26/Ea	\$6,183.78
						X3			SEP 27 2019				DP
2	199131	RBW6522A00231-W142AK-3TP			Tail Rotor Gear Box/Mast Output Oil Seal Assembly Press Tool As Per Dwg RBW6522A00231-W142AK-3T Rev. 1	Firmed -		10/2/19	5 Ea	0 Ea	5 Ea	\$185.00/Ea	\$925.00
						X5			SEP 27 2019				DP
3	199132	RBW6522A00231-W142S-3TP			Tail Rotor Gear Box/Mast Output Oil Seal Assembly Support Tool As Per Dwg RBW6522A00231-W142S-3T Rev. 2	Firmed -		10/2/19	5 Ea	0 Ea	5 Ea	\$195.79/Ea	\$978.95
						X5			SEP 27 2019				DP
Grand Total:												\$8,087.73	



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044262



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 8/14/19 8:36 AM dart.lussier.patrick



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044262 Dated: 9/20/2019

Our Order / Job No: AWT-HB044262 A3 Order Qty: 5

Part Name: TRGB/MAST OUTPUT OIL SEAL ASSEMBLY SUPPORT TOOL

Part Number RBW6522A00231-W142S-3T

Lot Size: N/A Ship Date: 9/20/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6522A00231-W142S-3T Rev: 2

Material Size and Type: 6061 ALUM.

Material Specifications: ALUMINUM-ASTM B221

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE II, CLASS II

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 9/20/19

Signed: Hemant M. Sahi

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.attechmachineworks.com



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044694**



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044694
PO Date: 10/4/19
Due Date: 10/16/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201036-A	RBW6522A00231-W142AJ-3T-3	RBW6522A00231-W142AJ-3T 5	Base Plate (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	10/21/19	1 pcs	0 pcs	1 pcs	\$5.51/pcs	\$5.51
	201036				Firmed	-	10/22/19	5 pcs	0 pcs	5 pcs	\$5.51/pcs	\$27.55
Sub Total:								6	0	6		\$33.06
2	181397	647.1814	647.1800	Gusset LH : Various STC's ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	-	10/16/19	16 pcs	0 pcs	16 pcs	\$8.76/pcs	\$140.16
3	201205	SWA3-300	SWA3-300 3	Wire Clamp (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL- A-8625F TYPE 3 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	10/16/19	30 pcs	0 pcs	30 pcs	\$5.52/pcs	\$165.60



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PCHB044694



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	199122	RBT18608-2	RBT18608 2A	Weldment -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	10/16/19	10 pcs	0 pcs	10 pcs	\$5.51/pcs	\$55.10
5	199132	RBW6622A00231-W142S-3T	RBW6622A00231-W142S-3T 2	Tail Rotor Gear Box/Mast Output Oil Seal Assembly Support Tool (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG; -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Received	-	10/16/19	5 pcs	5 pcs	0 pcs	\$5.51/pcs	\$0.00
Grand Total:												\$393.92

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/21/19 1:53 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918812

Date: 21-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
1 ea	Part: RBW6522A00231-W142AJ-3T-3 Base Plate Black Anodize per MIL-A-8625F, Type II, Class2, Water Sealant .0004-.0010" (4 - 1 mils). Job: 26267 PO: POHB044694		Rev: 5 Line: 1 DA 46 9-88
16 ea	Part: 647.1814 Gusset LH Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 9731-F-J19 Job: 26268 PO: POHB044694		Rev: A Expiry Date: 06/20 Line: 2
30 each	Part: SWA3-300 Wire Clamp Anodize per MIL-A-8625F, Type II, Class2, Black, .0004-.0010" (4 - 1 mils). Water Sealant Job: 26269 PO: POHB044694		Rev: 3 Line: 3
5 ea	Part: RBW6522A00231-W142S-3T Tail Rotor Gear Box/Mast Output Black Anodize per MIL-A-8625F, Type II, Class2, Water Sealant .0004-.0010" (4 - 1 mils). Job: 26271 PO: POHB044694		Rev: 5 Line: 5
RECEIVED			
Made in Canada.			



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918812

Date: 21-Oct-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
	ATG Delivery
Quantity	Description
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>OCT 21 2019</u> 9-89 Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.
	Made in Canada.